









Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE KIT
Job Number	: 33461		
Estimate Number	: 10532		
P.O. Number	: N/A	Part Number	: K10003
This Issue	: 7/10/2007 S.O. No. : N/A	Drawing Number	: IIN D205-634 REV D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : SMALL /MED FAB	Drawing Revision	: D
Previous Run	: 33460	Material	: N/A
Written By	:	Due Date	: 7/23/2007 Qty: 12 Um: Each
Checked & Approved By	:		
Comment	: Est: 03.01.16 Reformat Incorporated D205-641-011 KJ/RF Est: J 06-07-25 As per DSI 9344 JLM Est: K 06.11.17 Per K10003 Rev C KJ Est Rev: L 07.01.12 Document Record for copying bluefile rmv KJ		

Job Number:

Seq. #:	Machine Or Operation:	Description :								
1.0	DC	DOCUMENT CONTROL								
 										
Comment: DOCUMENT CONTROL Create White labels only per PPP K10003 CHG 005										
2.0	PACKAGING 1	PACKAGING RESOURCE #1								
 										
Comment: PACKAGING RESOURCE #1 Pick Packing Kit										
3.0	D2570	Bushing								
 										
Comment: Qty.: 24.0000 Each(s)/Unit Total : 288.0000 Each(s) Bushing Pick: <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>24</td> <td>D2570</td> <td>Bushing</td> <td>033468</td> </tr> </tbody> </table>			Qty	Part Number	Description	Batch	24	D2570	Bushing	033468
Qty	Part Number	Description	Batch							
24	D2570	Bushing	033468							
4.0	D2571	Saddle, Fwd, Out								
 										
Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s) Saddle, Fwd, Out Pick: <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>D2571</td> <td>Saddle</td> <td>331806</td> </tr> </tbody> </table>			Qty	Part Number	Description	Batch	1	D2571	Saddle	331806
Qty	Part Number	Description	Batch							
1	D2571	Saddle	331806							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 7/10/2007 1:06:47 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE KIT

Job Number: 33461

Part Number: K10003

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0 D2572 Saddle, Fwd, In
Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)
Saddle, Fwd, In
Pick:
Qty Part Number Description Batch
1 D2572 Saddle B31720

6.0 D2573 Saddle, Aft, Out
Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)
Saddle, Aft, Out
Pick:
Qty Part Number Description Batch
1 D2573 Saddle B32167 (10X) - B31721 (2X)

7.0 D2574 Saddle, Aft, In
Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)
Saddle, Aft, In
Pick:
Qty Part Number Description Batch
1 D2574 Saddle B31722 (6X) - B32168 (6X)

8.0 D27361 Lug Assembly
Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)
Lug Assembly
Pick:
Qty Part Number Description Batch
1 D2736-1 Bracket D32511

9.0 D27363 Lug Assembly
Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)
Lug Assembly
Pick:
Qty Part Number Description Batch
1 D2736-3 Bracket D33082

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 7/10/2007 1:06:47 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE KIT

Job Number: 33461

Part Number: K10003

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0 D2747 Set Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 48.0000 Each(s)

Set Screw

Pick:

Qty	Part Number	Description	Batch
4	D2747	Socket Head Set Screw	B33470-

11.0 D2876 Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 24.0000 Each(s)

Saddle Spacer

Pick:

Qty	Part Number	Description	Batch
2	D2876	Spacer	B31227-

12.0 D2877 Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 24.0000 Each(s)

Saddle Spacer

Pick:

Qty	Part Number	Description	Batch
2	D2877	Spacer	B30055 (6x) B32104 (18x)

13.0 D2968041 Tow Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Tow Ring

Pick:

Qty	Part Number	Description	Batch
1	D2968-041	Tow Ring	B33287 (9x) B29836 (3x)

14.0 D35331 Set Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 24.0000 Each(s)

Set Screw

Batch: B28093-

15.0 AN46A Bolt



Comment: Qty.: 16.0000 Each(s)/Unit Total : 192.0000 Each(s)

Bolt

Pick:

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 7/10/2007 1:06:47 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE KIT

Job Number: 33461

Part Number: K10003

Job Number:



Seq. #:

Machine Or Operation:

Description :

Qty Part Number Description Batch
16 (12) AN4-6A Bolt M105057-

16.0

AN446A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 48.0000 Each(s)

Bolt

Pick:

Qty Part Number Description Batch
4 AN4-46A Bolt M104975-

17.0

AN451A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 96.0000 Each(s)

Bolt

Pick:

Qty Part Number Description Batch
8 AN4-51A Bolt M105107(142) M103684(82)-

18.0

AN612A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 96.0000 Each(s)

Bolt

Pick:

Qty Part Number Description Batch
8 AN6-12A Bolt M103668(95x) M105558 1X

19.0

AN960JD416

Washer



Comment: Qty.: 32.0000 Each(s)/Unit Total : 384.0000 Each(s)

Washer

Pick:

Qty Part Number Description Batch
32 AN960JD416 Washer M104215-

20.0

AN960JD616

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 96.0000 Each(s)

Washer

Pick:

Qty Part Number Description Batch
8 AN960JD616 Washer M104537-

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: 12 Date: 07/09/11
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 7/10/2007 1:06:47 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE KIT

Job Number: 33461

Part Number: K10003

Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

AN9704

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)

Washer

Pick:

Qty

Part Number

Description

Batch

1

AN970-4

Washer

11103344 -

22.0

MS21042L4

Nut



Comment: Qty.: 29.0000 Each(s)/Unit Total: 348.0000 Each(s)

Nut

Pick:

Qty

Part Number

Description

Batch

29

MS21042L4

Nut (or MS21042-4)

11104248 -

23.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT KITS 100% FOR COMPLETENESS

24.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: H

7/9/11

SC

12x

25.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



UL 07/09/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED #	DRAWING NO. K10003	REV. C SHEET 1 OF 1
DATE 06.11.07		TITLE SADDLE KIT	SCALE NTS
A	00.06.01	NEW ISSUE	
B	00.11.22	ADD D2707-041 OPTION	
C	06.11.07	ADD D3533-1	

RELEASED

06.11.13

THIS KIT CONTAINS PARTS AND PAPERWORK APPLICABLE TO THE FOLLOWING SKIDTUBE AND SADDLE INSTALLATIONS:

AIRCRAFT	INSTALLATION
BELL 205/210/212/412	D205-634-011 D205-634-015
BELL 204	D204-635-011

THE FOLLOWING PARTS SHOULD BE USED PER THE RELEVANT DRAWINGS AND THE FOLLOWING TABLE (REF):

PART NUMBER	K10003	D205-634-011 D205-634-015	D204-635-011
D205-641-011	1	1	1
D2570	16	16	16
D2571	1	1	1
D2572	1	1	1
D2573	1	1	1
D2574	1	1	1
D2747	4	4	4
D2876	2	2	2
D2877	2	2	2
D2707-041 (or D2968-041)	1	1	1
D3533-1	2	2	2
AN4-51A	8	8	8
AN4-6A	16	16	16
AN6-12A	8	8	8
AN960JD416	32	32	32
AN960JD616	8	8	8
*AN960JD1016	1	1	1
AN970-4	1	1	1
MS21042-4 (OR L4)	25	25	25

* REQUIRED WITH D2707-041 ONLY

NO 33461

Copyright © 2000 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.